

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2016-45 Date Opened: 21 Mar 16 Title: AssemblyAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Cargo Basket Product Model: Ski Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

JR
N/A
JR
JR
JR
JR
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JR
JR

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
94610	0	Basket	JR
94611	1	Body	JR
94612	0	Lid	JR
94627	0	Placard	JR
70405	4	Walkway	JR

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

JR
JR
JR
JR
JR
JR
JR

Work performed by:

Print: Drew BartfaiSign: [Signature]SCA: AD07Date: 24-Mar-16

ICC / Dual Inspection preformed by:

Print: Jason RekveSign: [Signature]SCA: AD01Date: 24-Mar-16

Work Order closed by:

Print: Jason RekveSign: [Signature]SCA: AD01Date: 24-Mar-16

Approved Manufacturing Facility 73-04

Form 20.0.03

Rev. Original 23 Sep 2014

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JR
N/A
N/A

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2016-45

Bell 206L/407 SK1

Date Open: 21 Mar 16

AD-07

### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

### 2. Body Assembly

AD-07

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??



- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

## 3. Hinge Installation

AD-07

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

AD-07

#### 4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

#### 5. Install lid brace

AD-07

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

AK

### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.



## CARGO BASKET HANDLE FABRICATION

### General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2016-45

Complete  
(initial or SCA #)

Date Open: 21 Mar 16

AD-07

1. Weld Lever Assembly – handle lever jig required
  - a. Set MS20615-4M3 monel rivet into socket in jig
  - b. Set 36274-01 bushing into socket in jig
  - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
  - d. TIG weld around bushing using ER308L rod.
  - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
  - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
  - g. Record material POs on attached material list.

2. Clean up
  - a. Clean lever assembly by media blasting with glass bead.
  - b. Drill out lever bushing to O (0.316) on lathe:
    - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
    - ii. Run at 300 RPM.
    - iii. Apply a drop of Rapid-Tap to drill.
  - c. De-burr.

3. Fabricate Handle Assembly
  - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
  - b. Measure across TOP side of levers.
  - c. Cut handle tubing to length measured.
    - i. Handles under 40" long: 1.0" x 0.035 round tube
    - ii. Handles over 40" long: 1.0" x 0.065 round tube
  - d. De-burr tube.
  - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
  - f. Record material PO on attached material list.

AD-07

4. Weld Handle Assembly
  - a. Fuse tube to lever on both ends. Ensure levers are parallel.

AD-05

5. Clean up
  - a. Clean welded area with scotch-brite.

AD-07

6. Final Inspection –

To be completed by a different person than the previous steps.

  - a. Welds for complete and handle for fit.
  - b. Tag complete and inspected parts in preparation for installation.

OR



**Aero Design**  
**Parts Distribution Sheet**

Description: Bell 206L/407 Wide Basket Assy

WO# 2016-45

From PO or WO #	Quantity	Description	Material	Part Number
		<b>Cargo Basket Assembly</b>		<b>94510-01</b>
		<b>Lid Assembly</b>		
2016-28	1	Basket Lid Assembly		69812-01
15025	3	Bumper	Argus Industries Bumper	49205-14
N/A	A/R	Sealant	Commercial Silicone RTV sealant	
94601-15	1	Placard	0.063 Sheet, 6061-T6 Aluminum	94527-01
15031	4	Cherry Rivet		CR3213-4-02
	1	Lid Step Modification		70405-01
	1	Tread Plate	3003 Aluminum Tread Plate, 0.063"	70405-04
15031	A/R	Cherry Rivet		CR3213-4-02
N/A	A/R	Sealant	Commercial Silicone RTV sealant	
		<b>Basket Assembly</b>		
2016-28	1	Basket Body Assembly		94511-01
	4	Fitting	Alternate: Ancra 40088-14	96710-01
	8	Washer		NAS1149F0663P
		<b>Hinge Installation</b>		
15069	1	Piano Hinge	72"	MS20001P4
16005	8	Cherry Rivet		CR3523-5-02
15086	A/R	Cherry Rivet		CR3213-5-02
		<b>Handle Installation</b>		
+DB	1	Handle Assembly		84255-01
16001	2	Bracket	Delrin, 3/4" Sheet	84267-01
	4	Bolt		AN3-11A
	8	Washer		NAS1149F0363P
	4	Nut		MS21044N3
15073		1" X .063 SS tube		
	1	Handle Assembly		84261-01
	2	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	36278-01
	2	Bushing	Brass, 5/16" Dia	36275-01
	2	Bolt		AN3-12A
	4	Washer		NAS1149F0363P
	2	Nut		MS21044N3
2015-122	2	Lever Assembly		
		<b>Lid Brace Installation</b>		
2016-32	1	Brace Assembly		36280-01
14084	1	Bolt		AN3-15A
13084	1	Bolt		AN3-17A
15014	2	Washer		AN970-3
16005	3	Washer		NAS1149F0363P
15086	2	Nut		MS21044N3
		<b>Inspection</b>	<b>None</b>	

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

Work Order: 2016-45

## Material Tracking Sheet

1 of 1

Bell 206L / 407

Date Opened: 21 Mar 16

## Extra Wide Ski Basket Handle Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>	84261	<b>84261-01</b>	<b>Handle Assembly</b>		
<b>Step 1</b>				<i>Weld Lever Assembly</i>		<u>2015-122</u>
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	<u>13028</u>
	. 2		MS20615-4M3	Rivet		<u>13026</u>
	. A/R		--	Welding Rod	ER308L TIG Rod	<u>14028</u>
<b>Step 2</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 3</b>				<i>Fabricate Handle Bar</i>		
	. 1		36277-01	Handle Bar	304 Stainless, 1.0 x 0.065 Rnd. Tube	<u>15073</u>
<b>Step 4</b>				<i>Weld Handle Assembly</i>	<i>None - Fuse weld, no rod req.</i>	
<b>Step 5</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 6</b>				<i>Inspection - Final Assembly</i>	<i>None</i>	





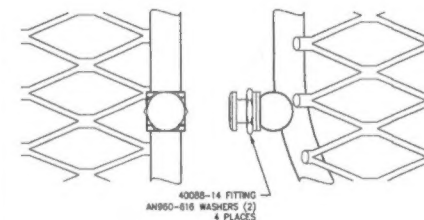
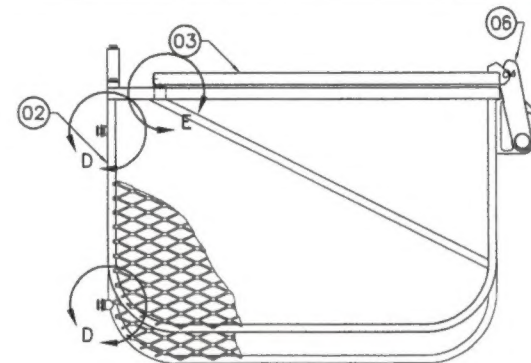
WO# \_\_\_\_\_

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 94511, REV. 0		






DETAIL D

SCALE 1 : 1  
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR  
TYPICAL FRONT AND REAR



SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

BASIC CODE REF: NAS 523 C-COUNTERSUNK DIGIT# OF SHEETS D-DIMPLED BASIC CODES: BB=MS20470AD BB=MS20470AD ARN=CR3213 ATW=CR3523		DASH NO. FOR DIAMETER N=MFED. HEAD REAR SIDE F=MFED. HEAD FAR SIDE DASH NO. FOR LENGTH +  INSTALL NEW RIVET +  REMOVE/REPLACE RIVET -  EXISTING RIVET	APPROVALS _____ DATE _____ DRAWN: JEFF CLARKE 24 OCT 2019 CHECKED: E BURGIN UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: ANGLES DECIMALS .0000 ±.010 .XX ±.0.3 .X ±.0.3
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4	AN850-418	WASHER	
2	AN4-30A	BOLT	
2	AN4-6A	BOLT	
A/R	AN850-616	WASHER	
4	40088-14	FITTING	ANCRA
1	CR3213-4-02	CHERRY RIVET	
B	CR3523-5-02	CHERRY RIVET	
A/R	CR3213-5-02	CHERRY RIVET	
1	94821-01	09 BRACE	
4	49205-14	08 BUMPER	ARGUS INDUSTRIES
1	94821-01	07 PLACARD	
1	94255-01	06 HANDLE BAR INSTALLATION	
1	MS2001P4	05 PIANO HINGE	
1	36280-01	04 BRACE ASSEMBLY	
1	94817-01	03 LD ASSEMBLY	
1	94811-01	02 BASKET BODY ASSEMBLY	
1	94810-01	01 CARGO BASKET ASSEMBLY	
D1	PART NO.	ITEM DESCRIPTION	MATERIAL

**AERO DESIGN LTD.**

CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DNR 200M  
2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7  
tel: (403) 250-8827 fax: (403) 250-8333 aerodesign@caluglanet.net

BELL 206L SERIES, 407  
QUICK RELEASE CARGO BASKET  
CARGO BASKET ASSEMBLY

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.	
SHEET 1 OF 1	A1	94610	0	



**NOTES**

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY CTAB METHOD TO AWS B583C WELDING ROD SHALL CONFORM TO ENTOS-2 OR EQUIVALENT
3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSEHILL WELD
4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLY PRIOR TO ASSEMBLY

**DETAIL D**  
SCALE 1:1  
VIEW LOOKING AT FRONT END OF BASKET

**DETAIL B**  
SCALE 1:2  
VIEW LOOKING UP AT BASKET END  
WELD NOT SHOWN FOR CLARITY

**VIEW F**  
SCALE 1:2  
VIEW LOOKING UP AT BASKET END

**DETAIL C**  
SCALE 1:2  
VIEW LOOKING UP AT BASKET END

**SECTION E-E**  
SCALE 1:2  
VIEW LOOKING THROUGH BASKET

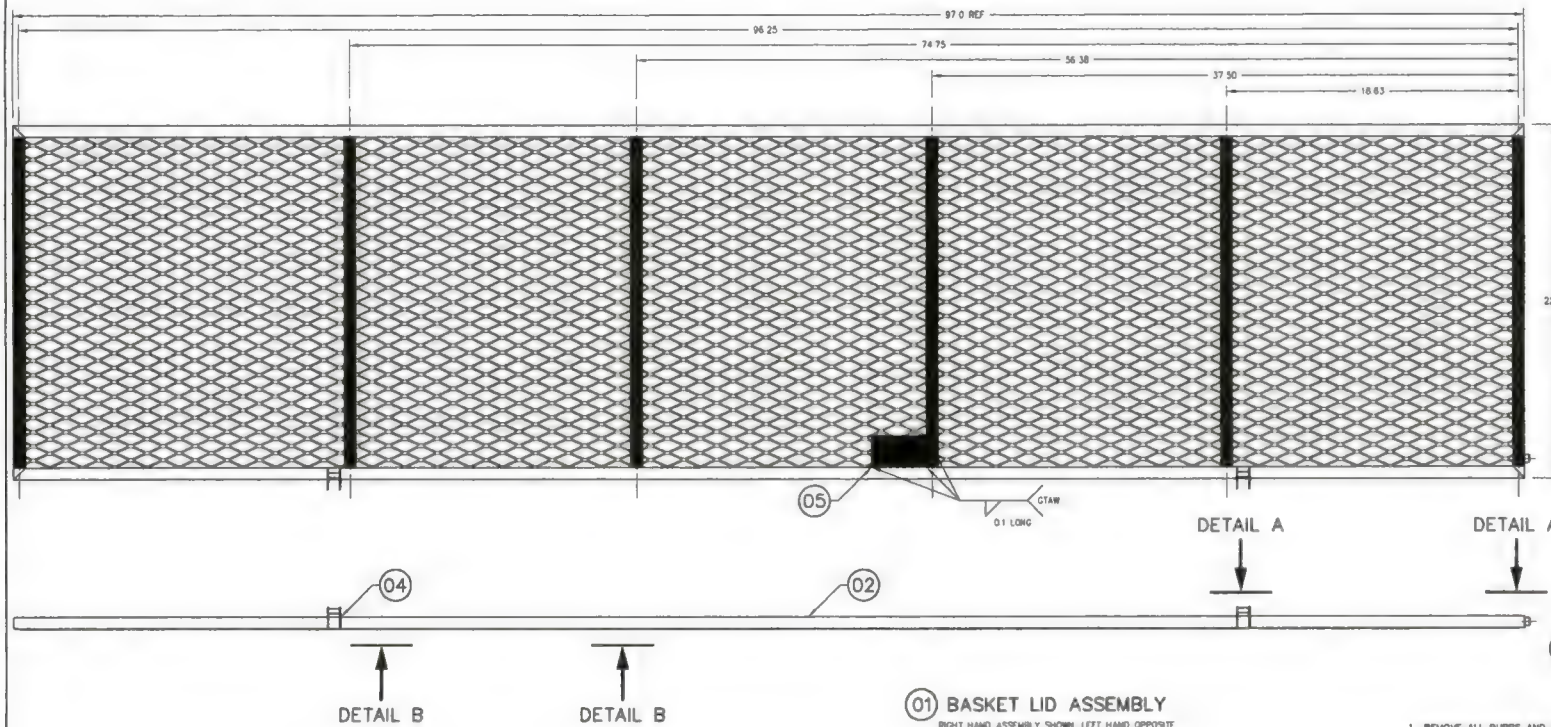
**LIST OF MATERIALS**

QTY	PART NO.	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK NO.
1	01	BASKET BODY ASSEMBLY	STEEL	4130	
1	02	SPACER	4130		
1	03	WASHER	4130		
1	04	NUT	4130		
1	05	WASHER	4130		
1	06	NUT	4130		
1	07	WASHER	4130		
1	08	NUT	4130		
1	09	WASHER	4130		
1	10	NUT	4130		
1	11	WASHER	4130		
1	12	NUT	4130		

**AERO DESIGN LTD.**  
BELL 206L SERIES, 407  
QUICK RELEASE CARGO BASKET  
BASKET BODY ASSEMBLY  
SCALE 1:2  
SHEET 1 OF 1

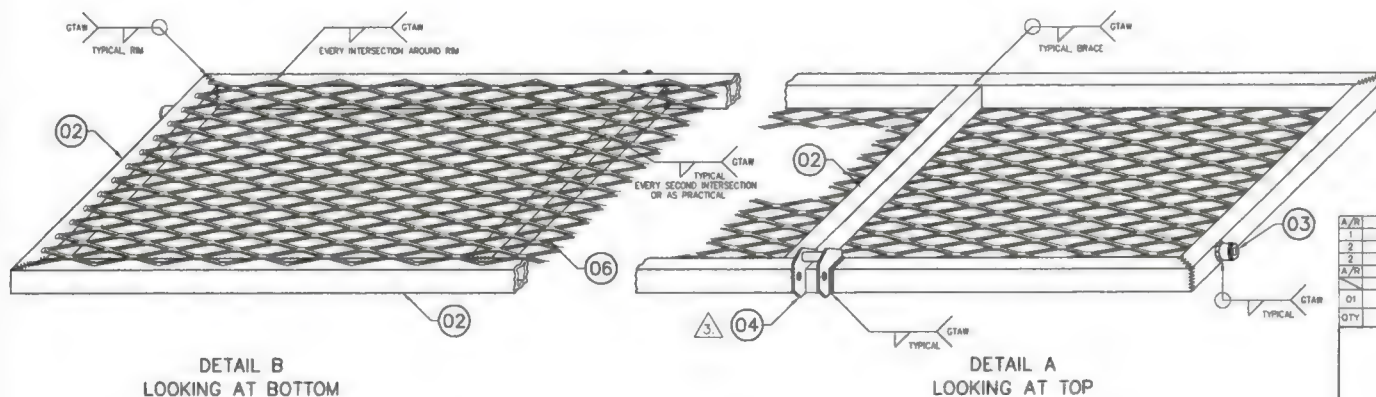


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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL RELEASE		



**01 BASKET LID ASSEMBLY**  
RIGHT HAND ASSEMBLY SHOWN, LEFT HAND OPPOSITE

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2885C
3. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
4. INSTALL ITEM 8 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84262 TYP 2 PLACES.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY



**DETAIL B**  
LOOKING AT BOTTOM

**DETAIL A**  
LOOKING AT TOP

A/R	1	3/4-16F	06	MESH	MILD STEEL	COMMERCIAL	
	2	36204-10	05	PLACARD BRACKET			
	3	84262	04	UPPER HANDLE BRACKET ASSY			
	4	49216-01	03	SPACER			
A/R	5	02	10TH				
	6	68812-01	01	BASKET LID ASSEMBLY	4130 STEEL, COND N	MIL-T-6756	0.75 X 0.035 SQB TUBE
QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
LIST OF MATERIALS							
APPROVALS				DATE			
DRAWN: JEFF CLARKE				29 SEPT 2014			
CHECKED: E BURGON							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:				AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 280M 8015 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 Tel: (403) 250-8027 Fax: (403) 250-8993 aerd@adltd.com			
DECIMALS							
X.XXX ±0.010				±1/2°			
X.XX ±0.03							
X.X ±0.1							
SCALE 1 : 4				REV			
SHEET 1 OF 1				A1 94612 0			

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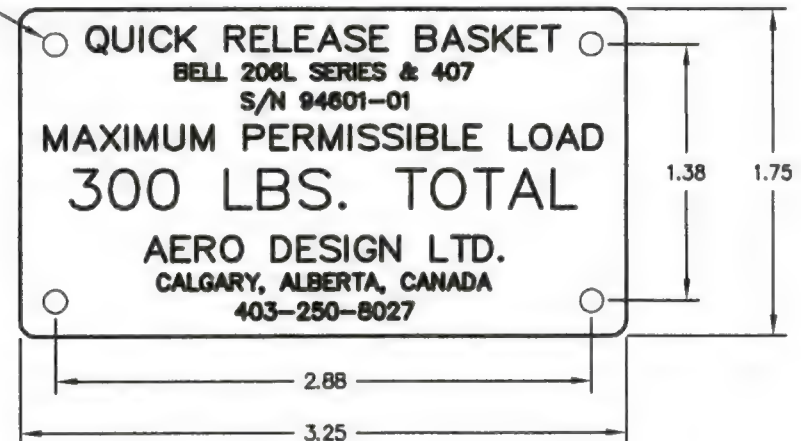
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	ORIGINAL ISSUE		

## NOTES

### 1. ENGRAVE 0.007 DEEP AS FOLLOWS:

- "QUICK RELEASE BASKET" - 0.125 HIGH
- "BELL 206L SERIES & 407" - 0.080 HIGH
- "S/N 94601-XX" - 0.080 HIGH
- "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
- "300 LBS. TOTAL" - 0.200 HIGH
- "AERO DESIGN LTD." - 0.125 HIGH
- "CALGARY, ALBERTA, CANADA" - 0.080 HIGH
- "403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)  
4 PLACES



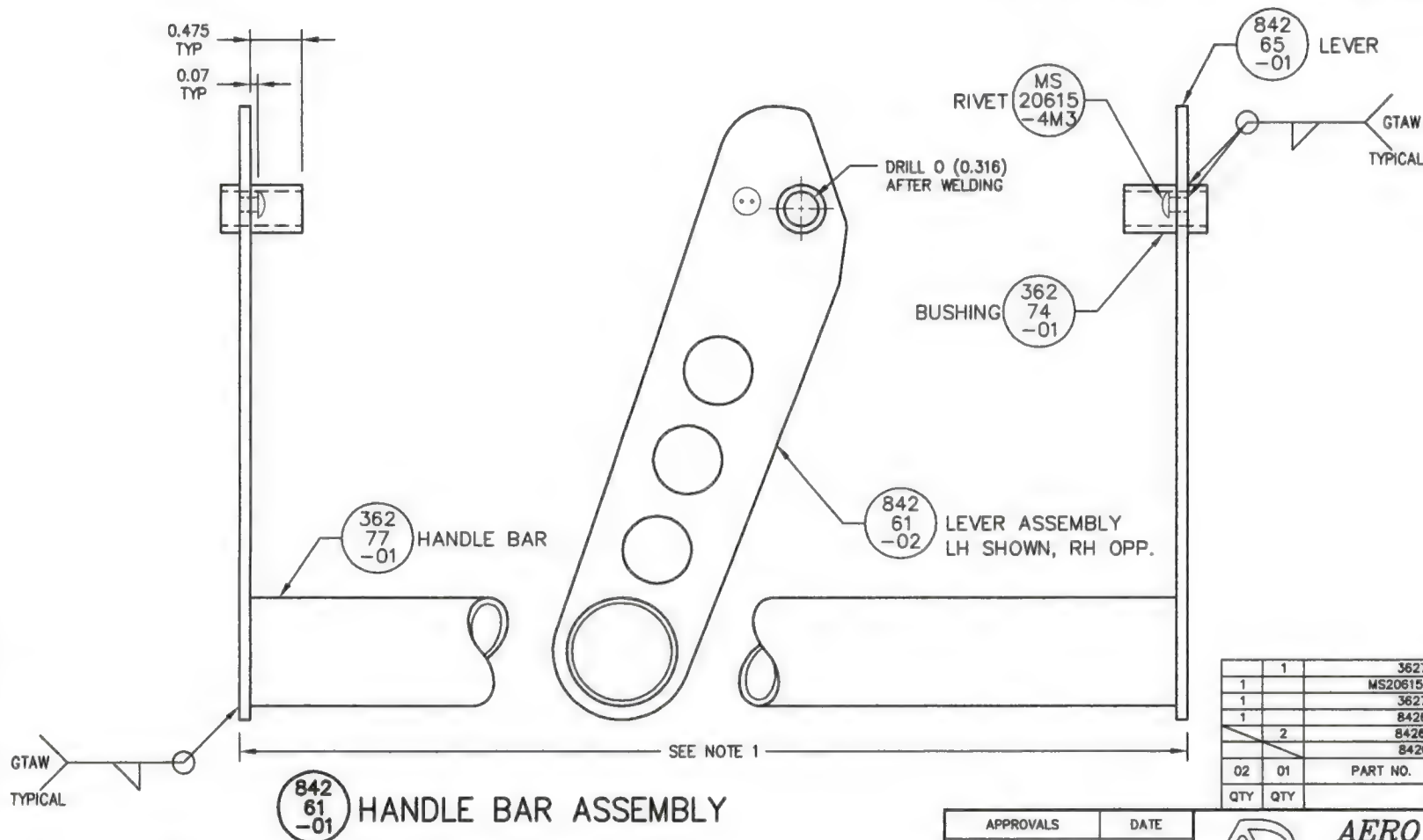
01 PLACARD

1	94627-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@teiusplanet.net	
			DRAWN: JEFF CLARKE	16 SEPT 2011		
			CHECKED: E. BURGAIN			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET PLACARD	
			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1	A1	94627	0

2016-45

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



## NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1	1	36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
02	01	84261-01	HANDLE BAR ASSY

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



AERO DESIGN LTD.

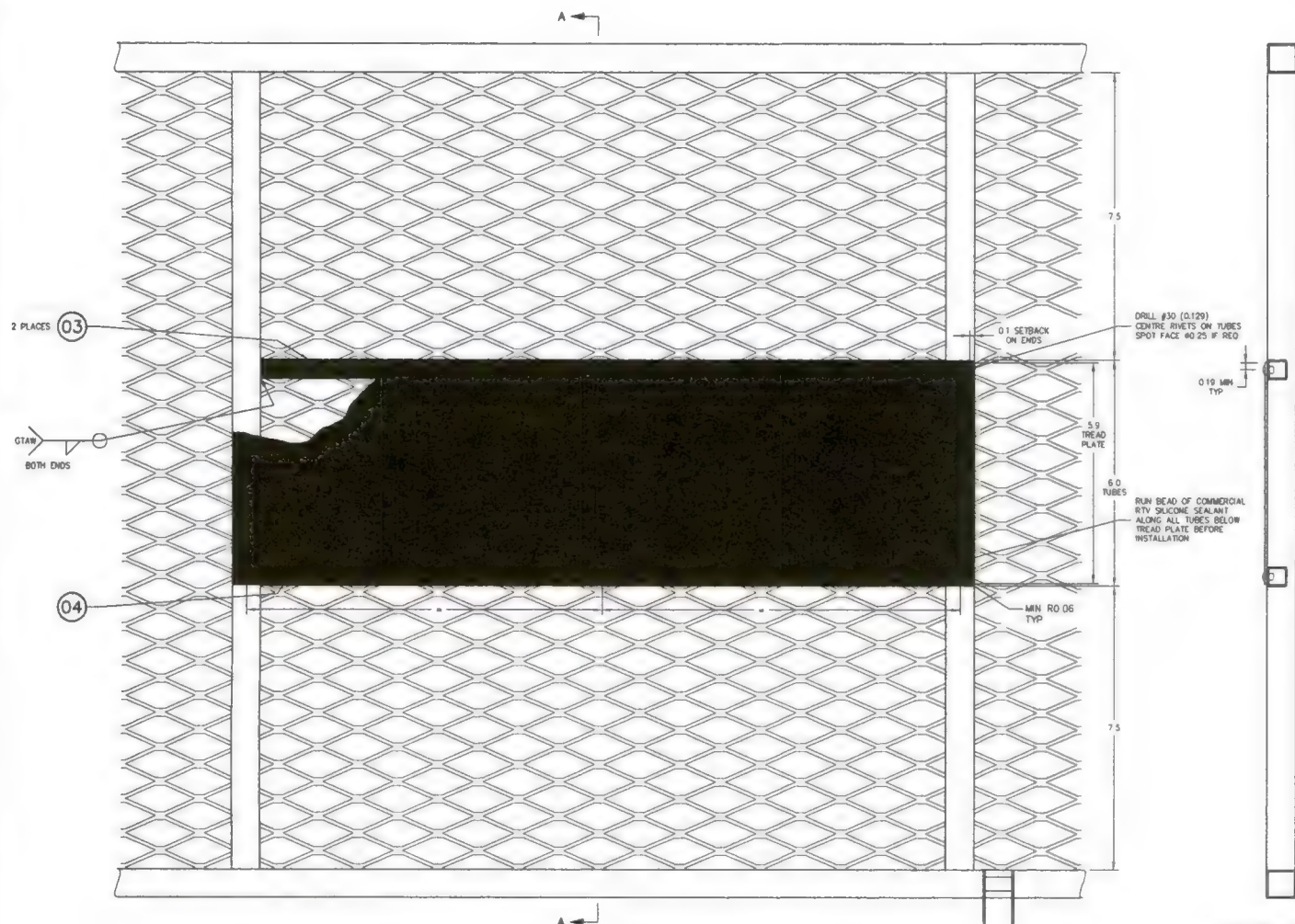
9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.489.8976 www.aerodesign.ca

HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2
SHEET 1 OF 1			



THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCCONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW 45350 AND 208L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED, MODEL LIST REMOVED, ADD ALT RIVET, ADD NOTE 7	BJC	25/05/2014




#### NOTES:

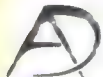
- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY ON ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

#### SECTION A-A

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE	HR3213-4-02		
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.083 TREAD PLATE	
2	70405-03	03 TUBE	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	02 BASKET LID ASSEMBLY				
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
D1	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF: NAS 523 C=COUNTERSUNK D=DIMPLE DIGIT= # OF SHEETS TO BE DIMPLED BASIC CODES BL=MS20470AD BB=MS20426AD ARN=CR3213 ARN=CR3212		DASH NO. FOR DIAMETER N=MFD. HEAD REAR SIDE F=MFD. HEAD FAR SIDE DASH NO. FOR LENGTH + INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		APPROVALS DRAWN: JEFF CLARKE 21 SEPT 2008 CHECKED: E. BURGOIN UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X XXX ±0.010 ±1/2° X XX ±0.03 X X ±0.1		DATE 21 SEPT 2008 AERO DESIGN LTD. 8888A MALAPENNA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 864 483.2276 www.aerodesign.ca	
CARGO BASKET LID STEP MODIFICATION				SCALE 1:15 SHEET 1 OF 1		DWG. NO. 70405	
				REV. 4			

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No. <b>2016-45-1</b>	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2016-45</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Cargo Basket</b>	<b>94610-01</b>	<b>1</b>	<b>94601-15</b>	<b>New</b>	
12. Remarks <b>Modified with Lid Walkway IAW DCL704</b>						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.						
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jason Rekve – AD01</b>		13e. Date (dd/mm/yyyy) <b>24 Mar 2016</b>		14d. Name		14e. Date (dd/mm/yyyy)
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	25	
Part No.:	MS20001P4-9600	
Aircraft:	All	Model: All
Description:	Hinge	
Supplier:	GKN Bandy	
Color:	N/A	
WO#:	N/A	PO# 15069





## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

**Quantity:** 1

**PN:** 94621-01

**Aircraft:** Bell

**Model:** 407

**Description:** Brace

**Supplier:** Aero Design

**Color:** N/A

**WO#:** 2015-121

**PO#** N/A



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

Aluminum Checker plate

Aircraft:

All

Model: All

Description:

5 7/8" x 10", .065", pattern c102

Supplier:

Daigle Marine

Color:

N/A

WO#:

N/A

PO# 15056



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

69830-02

Aircraft:

Bell

Model: 206L/407

Description:

Forward Beam

Supplier:

Aero Design

Color:

White

WO#:

2015-68

PO# N/A





## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

69831-02

Aircraft:

Bell

Model: 206L/407

Description:

AFT Beam

Supplier:

Aero Design

Color:

White

WO#:

2015-68

PO# N/A



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 2061/407 low skilled No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 94612-01 Serial No.: NISN

TTSN: NP TSO: N/A Rem.: N/A

Work Order No.: 2016-28

Remaining Tasks to be Performed: Assemble

Signature: [Signature]

Date: 21 Mar 16 Lic. No. / SCA AD01

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

Remarks

Serviceable

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 2064407 lawski body No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 94611-01 Serial No.: NSN

TTSN: NP TSO: N/A Rem.: N/A

Work Order No.: 2016-28

Remaining Tasks to be Performed: Assemble

\_\_\_\_\_

Signature: Adam Reh

Date: 21 Mar 16 Lic. No. / SCA AD01





Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

Remarks

Serviceable

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Handle BracKet No. of pieces: 2

Manufacturer: Aero Design Ltd

Part No.: 84267-01 Serial No.: PO 16001

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-37

Remaining Tasks to be Performed: Complete

Signature: Don Butts Asa Reh AD01

Date: March 24th/2016 Lic. No. / SCA AD-07



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**Serviceable**

**Remarks**

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